

Work Order ID 123015

Wednesday, October 08, 2014 3:23:48 PM

\*123015\*

Page 1

Item ID: D4653-045

Accept

\*N9000040100\*

Setup Start

\*NS1\*

Revision ID:

Stop

\*NS2\*

Item Name: Fitting Assembly

Start Date: 8/20/14 Start Qty: 24.00

\*24\* 12

Cust Item ID:

Required Date: 8/20/14 Req'd Qty: 24.00

\*24\*

Customer:

Reference:

Approvals: Process Plan:

Date: 10/10/14

Tooling:

Date:

Run Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D4653

REV A

110

Pick Kit

0.00

\*110\*

Packaging

Memo

0.00

Packaging

1/8 1/2 14-10-20

120

Weld per dwg A/R Aluminum rod Batch: 129599 0.00

\*120\*

Large Fab

Memo

0.00

Large Fab

GRIND FLUSH THE OUT SIDE EDGE AND INSIDE GRIND SMOOTH

1/8 1/2 14-10-20

130

QC9- Inspect visual per QSI004- Fusion Welds 0.00

\*130\*

QC

Memo

0.00

Quality Control

(13) 14-10-21 DAS 9 9-89

# Work Order ID 123015

Wednesday, October 08, 2014 3:23:48 PM

**\*123015\***

Page 2

Item ID: D4653-045 Accept **\*N9000040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Fitting Assembly  
 Start Date: 8/20/14 Start Qty: 24.00 **\*24\*** Cust Item ID:  
 Required Date: 8/20/14 Req'd Qty: 24.00 **\*24\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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140

QC5- Inspect part completeness to step on W/O

0.00

**\*140\***

QC

Memo

0.00

Quality Control

(19)

14-10-21

DAS

9

9-89

150

Chemical Conversion Coat per QSI005 4.1

0.00

**\*150\***

HandFinish

Memo

0.00

Hand Finishing

18

14-10-21

14-10-21

DAS

38

9-89

160

QC7-Inspect Chemical Conversion Coat

0.00

**\*160\***

QC

Memo

0.00

Quality Control

(18)

OCT 21 2014





**Work Order ID 123015**

Wednesday, October 08, 2014 3:23:48 PM

**\*123015\***

Page 4

Item ID: D4653-045 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
Item Name: Fitting Assembly  
Start Date: 8/20/14 Start Qty: 24.00 **\*24\*** Cust Item ID:  
Required Date: 8/20/14 Req'd Qty: 24.00 **\*24\*** Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	QC21- Final Inspection - Work Order Release	0.00							
<b>*200*</b>									
QC	Memo	0.00							
Quality Control									

MCJ 14-12-24

14-12-23

# Picklist Print

Wednesday, October 08, 2014 3:23:57 PM

Page 1

Work Order ID: 123015

\*123015\*

Parent Item: D4653-045

\*D4653-045\*

Parent Item Name: Fitting Assembly

Start Date: 8/20/14

Required Date: 8/20/14

Start Qty: 24.00

Required Qty: 24.00

Comments: IPP REV:A 12.06.08 NEW ISSUE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4654-3		Manufactured	No				Each	70.0000		24			
<b>*D4654-3*</b>									**				
O-Ring													

Location	Loc Qty	Loc Code
ST115	70	
117666	3	
122746	67	

D4653-7

Manufactured No

**\*D4653-7\***

Fitting, Large

110

Each

46.0000

1

24

\*\*

Location	Loc Qty	Loc Code
ST115	1	
114381	1	
WA002	45	
123108	9	
124462	36	

D4653-9

Manufactured No

**\*D4653-9\***

Fitting, Small

110

Each

46.0000

1

24

\*\*

Location	Loc Qty	Loc Code
WA002	46	
122521	8	
124172	38	

125121 x 12

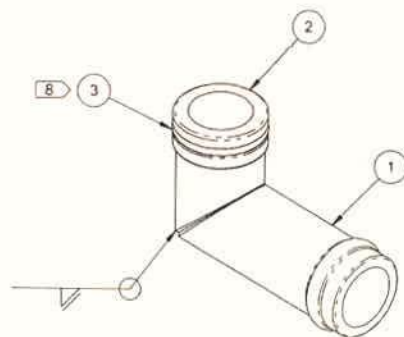
OCT 21 2014

FF

EL 14-10-20

EL 14-10-20

6



**D4653-045 FITTING ASSEMBLY**

ITEM	QTY -045	P/N	DESCRIPTION
	X	D4653-045	FITTING ASSEMBLY
1	1	D4653-7	LARGE FITTING
2	1	D4653-9	SMALL FITTING
3	1	D4654-3	O-RING

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.06 lbs
- 8) WELD PER QSI 004
- 9) CHEMICAL CONVERSION COAT PRIOR TO INSTALLING O-RING

*NP14-10-09  
123015*

**RELEASED**  
2012-11-05  
*MP*

DESIGN	<i>[Signature]</i>	<b>DART AEROSPACE LTD</b>	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4653	SHEET 2 OF 6
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	VENT MANIFOLD ASSY	NTS
DATE	12.07.25	<small>COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISCLOSED OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	